

Ship Jan 10

Work Order ID 110609

January-07-14 7:30:42 AM

110609

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Item ID: D2282-043

Revision ID:

Item Name: Saddle Assembly

Start Date: 1/07/14

Start Qty: 5.00

5

Required Date: 1/10/14

Req'd Qty: 5.00

5

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

NR1

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2282	Rev E								

100

0.00

100

Large Fab

Large Fab

Large Fab

Memo

0.00

1-Weld as per D2282-043 Saddle Assembly

A/RER316L SS

Filling Rod

Dwg Rev: m125054

5

14-01-08 MAL

110

0.00

110

Small Fab

Small Fab

Small Fab

Memo

0.00

1- Grind weld with rough pad and brown pad, take all welding marks out and deburr holes***DO NOT TAKE RED AND BLUE PAD TO BUFF PART***

5

14-01-08 MAL

120

QC9- Inspect visual per QSI004- Fusion Welds

0.00

120

QC

Quality Control

Memo

0.00

5

14-01-08

DAS

9

9-89

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Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

Start Date: 1/07/14 **Start Qty:** 5.00 ***5***

Required Date: 1/10/14 **Req'd Qty:** 5.00 ***5***

Customer:

Reference:

Run Start *NR1*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop *NR2*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

130

130

Small Fab

Memo

Small Fab

1 -Tumble

150

150

QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

Identify as per dwg & Stock Location: GA (4x) 0.00

160

160

Packaging

Packaging

Memo

1x ship

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Item ID: D2282-043 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Saddle Assembly
Start Date: 1/07/14 Start Qty: 5.00 ***5*** Cust Item ID:
Required Date: 1/10/14 Req'd Qty: 5.00 ***5*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170	QC21 - Final Inspection - Work Order Release	0.00							
170									
QC	Memo	0.00							
Quality Control									

14-01-9
ME
14-01-09

Picklist Print

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Work Order ID: 110609
 Parent Item: D2282-043
 Parent Item Name: Saddle Assembly

Start Date: 1/07/14 Required Date: 1/10/14
 Start Qty: 5.00 Required Qty: 5.00

Comments: IPP Rev:A Removed from 9 Digit 05-12-02 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2281 Jack Saddle		Manufactured	No			100	Each	0.0000	1	5			
D2282-7 Tube		Manufactured	No			100	Each	50.0000	2	10			

110071 LMT H-0-08

2x B108630
 8x B93327

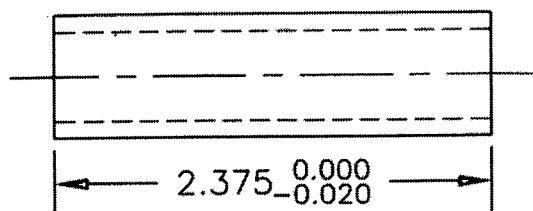
Location	Loc Qty	Loc Code
WA001	50	
108630	2	
109535	20	
93327	28	

x10 14-01-08 MAL

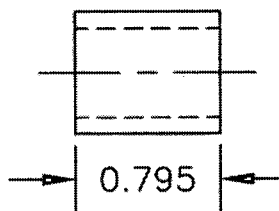


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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2282	REV. E SHEET 1 OF 2
DATE 05.06.07	TITLE HANDLE TUBES	SCALE 1:1	
A	94.10.14	NEW ISSUE	
B	95.03.23	RE-DESIGN	
C	97.10.20	CORRECTED NUMBERING SCHEME	
D	05.03.16	REDESIGN D2282-5; 0.795 WAS 0.750	
E	05.06.07	D2282-5 304 SS WAS 303 SS; R0.063 x 0.063 WAS R0.080 x 0.030	

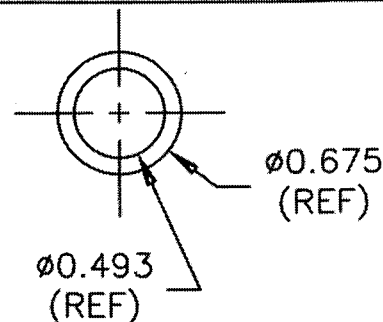
RELEASED
[Signature]
05/09/16



D2282-3

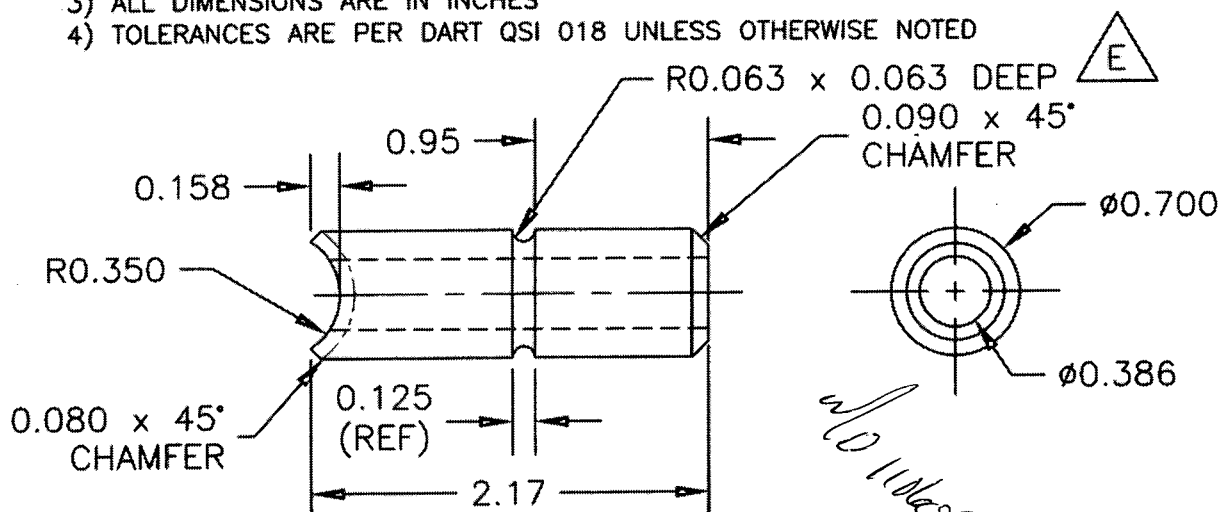


D2282-7



D2282-3/-7 TUBE:

- 1) MATERIAL: T304/T316 3/8 SCHEDULE 40 (REF. DART SPEC. M304TR0.675W.091)
- 2) BREAK ALL UMARKED SHARP EDGES 0.005 TO 0.010
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



D2282-5

D2282-5 STEM:

- 1) MATERIAL: AISI 304 STAINLESS STEEL (REF. DART SPEC. M304R0.750)
- 2) BREAK ALL UMARKED SHARP EDGES 0.005 TO 0.010
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

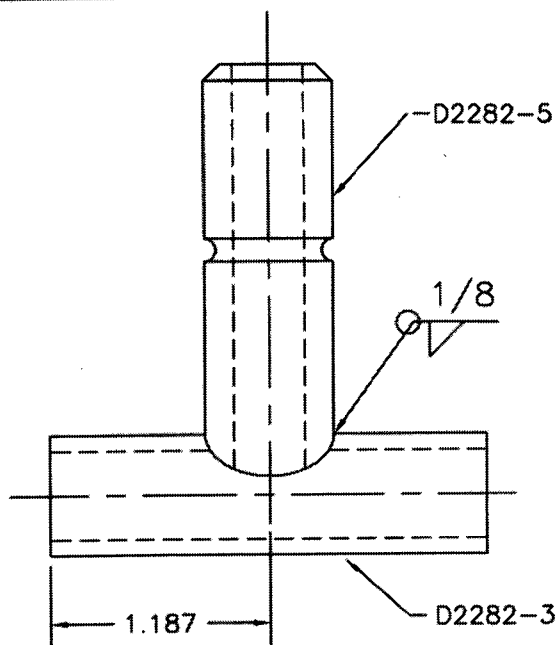


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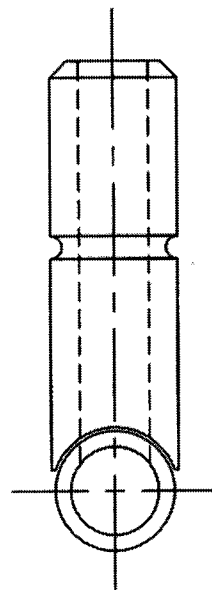
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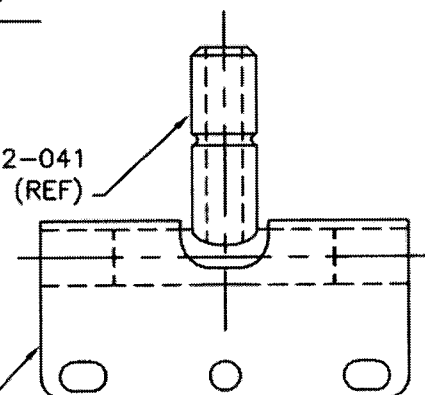
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CHECKED <i>UP</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2282	REV. E SHEET 2 OF 2
DATE 05.06.07	TITLE HANDLE TUBES		SCALE 1:1



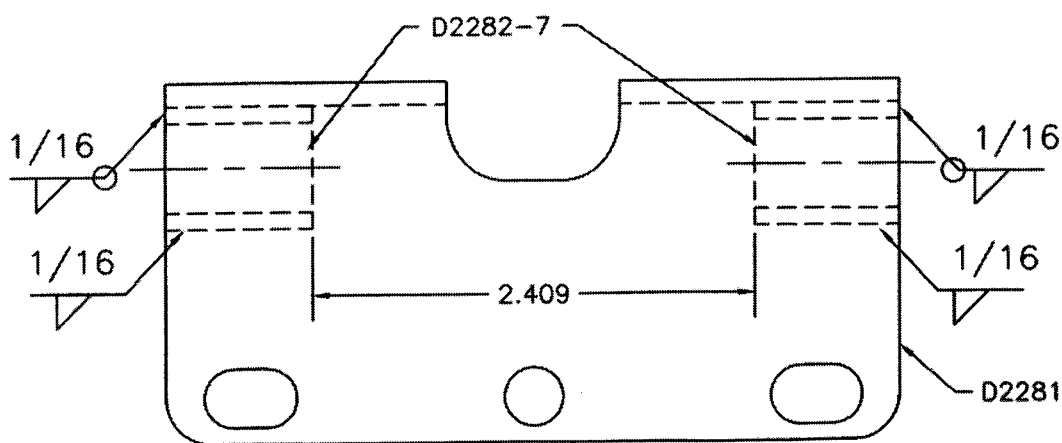
D2282-041 'T' ASSEMBLY
WELD ASSEMBLY PER DART QSI 004



D2282-041
(REF)



GENERAL ASSEMBLY
SCALE 1:2



D2282-043 SADDLE ASSEMBLY
WELD ASSEMBLY PER DART QSI 004

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